

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000666**Date Inspected:** 19-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG - Closed Rib Trials				

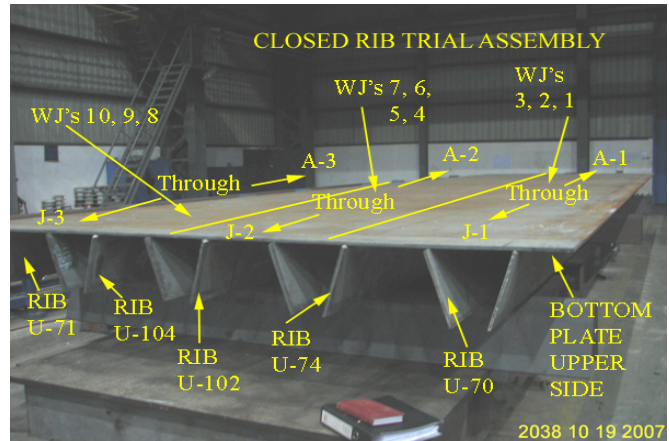
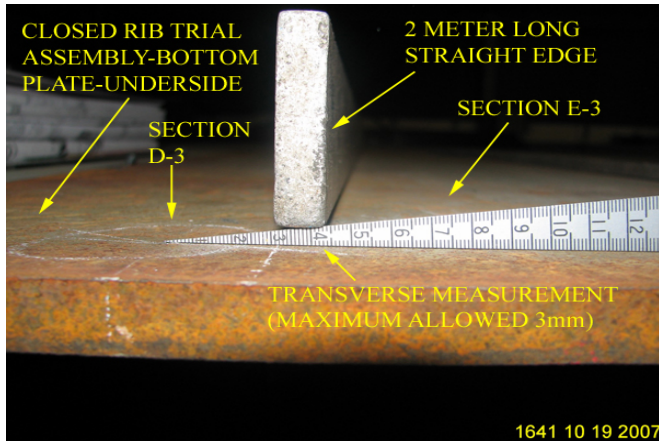
Summary of Items Observed:

OBG-CLOSED RIB TRIALS

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested by ZPMC QA Representative Eric Hu, to randomly verify transverse and longitudinal flatness of the Closed Rib Trial Assembly after the welding of the closed ribs onto the bottom plate of the Closed Rib Trial Assembly. The QA Inspector was assisted by QA Inspector Roscoe Dixon. The QA Inspector was informed by ZPMC QA Representative Fu Yuhong, that ZPMC had previously performed their verification of the transverse and longitudinal measurements. The QA Inspector utilized a 1 meter and a 2 meter straight edge to perform the flatness verification. The QA Inspector randomly observed that the underside of the bottom plate of the Closed Rib Trial Assembly, had been divided into sections A through J longitudinally and sections 1, 2 and 3 transversely. The QA Inspector randomly verified 30 readings in the transverse direction and 30 readings in the longitudinal direction. The readings were recorded and forwarded to the Lead QA Inspector. The QA Inspector randomly observed that there were 2 transverse readings and 2 longitudinal readings that were in excess of the maximum allowed per the contract requirements. These readings were highlighted on the verification sheet which was forwarded to the Lead QA Inspector. The attached photographs provide additional detail.

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Summary of Conversations:

ZPMC QC Representative Eric Hu informed the QA Inspector that the transverse and longitudinal verification measurements taken and recorded by ZPMC QC personnel, were performed with a level line on 50 millimeter blocks. Mr. Hu informed the QA Inspector that ZPMC had taken 15 longitudinal flatness verification measurements and 12 transverse flatness verification measurements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer